



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4776-1
Job Sheet 174571



Part No: D4776-1

Job Qty: 13 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/19/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	13 Ea	3/29/18	3/29/18	0.00	0.00	Start Up Machining-3		
100	Doosan	13 pcs	3/29/18	3/29/18	0.54	6.91	Doosan		
105	QC	13 pcs	3/29/18	3/29/18	0.00	0.00	QC2 Machining-3		
111	QC	13 pcs	3/29/18	3/29/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	13 pcs	3/29/18	3/29/18	0.00	0.37	HandFinish1		
113	QC	13 pcs	3/29/18	3/29/18	0.00	0.00	QC7-4		
115	Powdercoat	13 pcs	3/30/18	3/30/18	0.00	0.15	Powdercoat1		
116	QC	13 pcs	3/30/18	3/30/18	0.00	0.00	QC3		
130	Packaging	13 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3-2		
140	QC21-SA	13 Ea	3/30/18	3/30/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M108760 START: 11:45 OUT: 3:00 FINISH: 12:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	3.7700 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	4	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850		
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428		
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350		
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615		
5	Basket Strut Clevis	1.750Inches ± 0.030	1.780		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

			1.720	
6	Basket Strut Clevis	3.500Inches ± 0.030	3.530 3.470	
7	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle
8	Basket Strut Clevis	0.030Inches ± 0.030	0.060 0.000	
9	Basket Strut Clevis	0.060Inches ± 0.030	0.090 0.030	Radius
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter
12	Basket Strut Clevis	0.410Inches ± 0.030	0.440 0.380	Radius
13	Basket Strut Clevis	1.130Inches ± 0.030	1.160 1.100	
14	Basket Strut Clevis	0.188Inches ± 0.010	0.198 0.178	
15	Basket Strut Clevis	0.190Inches ± 0.030	0.220 0.160	
16	Basket Strut Clevis	0.500Inches ± 0.030	0.530 0.470	
17	Basket Strut Clevis	0.750Inches ± 0.010	0.760 0.740	
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter
19	Basket Strut Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	
21	Basket Strut Clevis	0.160Inches ± 0.030	0.190 0.130	
22	Basket Strut Clevis	45.000Degrees ± 0.500	45.500 44.500	Angle

Plex 3/19/18 9:08 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

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Container No: S052592
Part: D4776-1
Job No: 174571
Serial No/Batch: S052592
Revision:
Inspector:

Date: 03/19/18

FAULT CATEGORY

fect te/Unqualified	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Folio/Program	☐	Outside Dimensions
	☐	Grain	☐	Over/Under tolerance
	☐	Weld	☐	Part Incorrect
lete/Unclear	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Out of Sequence	☐	Part Moved
	☐	Off-set	☐	Drawing
	☐	Mislabeled	☐	Finish
	☐	Fit/Function	☐	Misread
	☐	Misaligned/off center	☐	Turning Sequence